

# DART SERVICE INSTRUCTION

TO AMEND MAINTENANCE MANUAL SUPPLEMENT MMS-D206-540

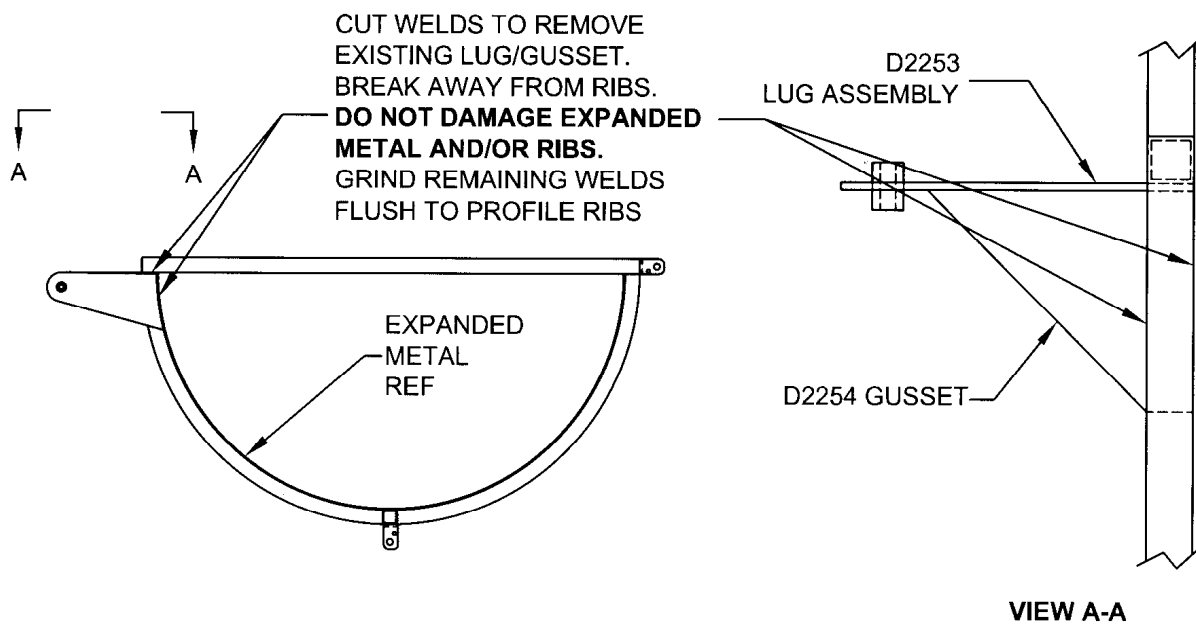
REF. CANADIAN STC: SH94-5

REF. FAA STC: SR00386NY

## FOR D206-540-013 B3071 ONLY

The D2253 Lug Assembly and D2254 Gusset can be replaced as follows:

- (1) Clean area of paint, etc...
- (2) Remove existing D2253 Lug Assembly and D2254 Gusset as shown in Figure 1.



**FIGURE 1 - REMOVAL OF EXISTING D2253 LUG ASSEMBLY  
AND D2254 GUSSET  
(2 PLACES AS REQUIRED)**

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AIRCRAFT CERTIFICATION  
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DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

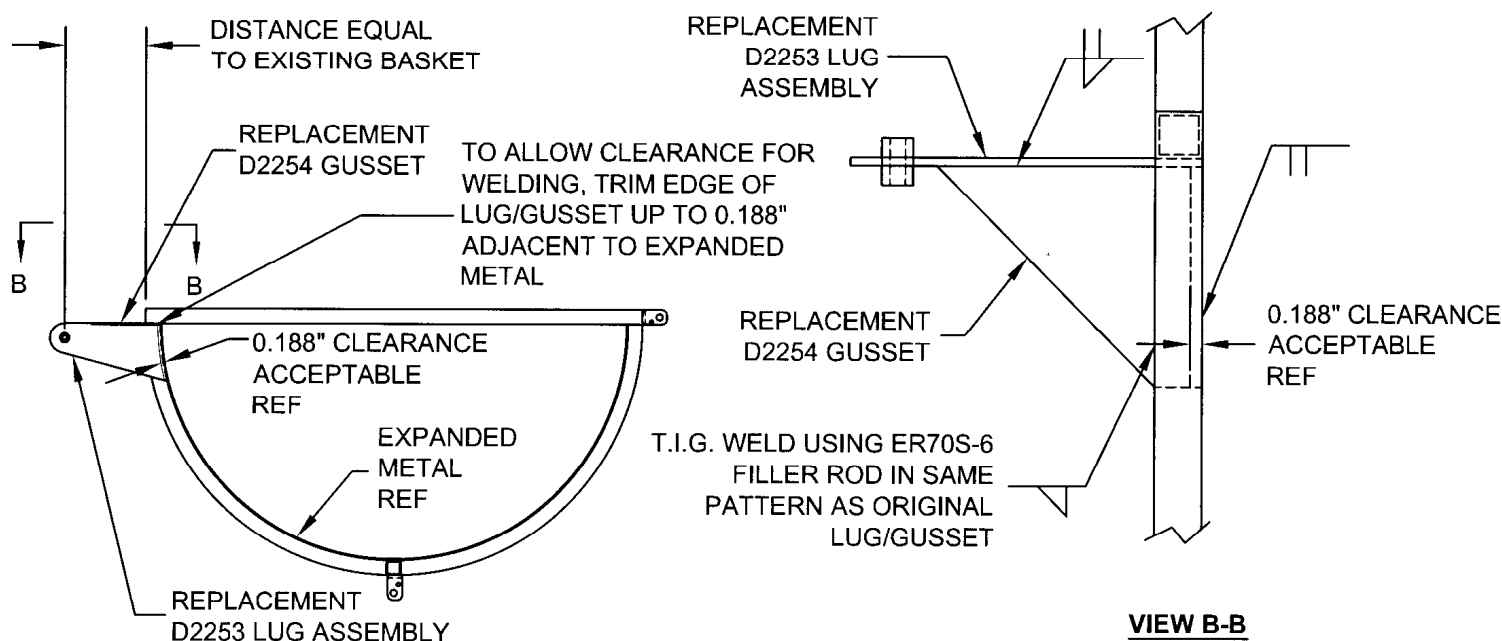
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CERT. NO.: SH94-5

ISSUE NO.: 4

A	NEW ISSUE	PH	08.02.27
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PA		
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9406	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	SH	BASKET BASE WELD REPAIR	NTS
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- (3) Install replacement D2253 Lug Assembly (Rev. A) and D2254 Gusset (made from AISI 1010-1025 steel) by welding per AMS-STD-2219 using ER70S-6 filler rod as shown in Figure 2 in same pattern as original lug assembly and gusset.
- (4) Touch up affected/repaired areas with one coat of MIL-P-85582 or MIL-P-23377 primer and 2-3 coats of MIL-C-85285 polyurethane paint to match original finish.



**FIGURE 2 - INSTALLATION OF REPLACEMENT D2253 LUG ASSEMBLY  
AND D2254 GUSSET  
(2 PLACES AS REQUIRED)**

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BY: *[Signature]*  
D. SHEPHERD (DE # 02)  
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MFG. APPR.	N/A	DSI 9406	SHEET 2 OF 2
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